DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-020035
Date Inspected: 07-Feb-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Mr. LI YAN HUA

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Segment

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Bay-14 Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the corner assembly to deck panel diaphragm web flange weld joint located on 13BE at Panel Point (PP-121.5). The weld is designated as SEG3009D-162. The welder is identified as 067571. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1. Further weld detail mention in attached picture.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to floor beam weld joint located on 13CE at Panel Point (PP-123). The weld is designated as SEG3011H-006. The welder is identified as 066881. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 298.0 Amps, Voltage 25.8

Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to floor beam weld joint located on 13CE at Panel Point (PP-123.5). The weld is designated as SEG3011F-006. The welder is identified as 214945. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 307.4.0 Amps, Voltage 25.0 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the corner assembly to floor beam weld joint located on 13CE at Panel Point (PP-124). The weld is designated as SEG3011D-154. The welder is identified as 052696. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 267.3 Amps, Voltage 27.3 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB. Further weld detail mention in attached picture.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the anchorage plate to longitudinal diaphragm weld joint located on 14E at bike path side. The weld is designated as SEG3019Z-009. The welder is identified as 067817. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The welding variables were recorded at, current 267.5 Amps, Voltage 27.1 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the anchorage plate to vertical shear plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-157. The welder is identified as 157. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the vertical shear plate to bottom plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-037. The welder is identified as 215553. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2737.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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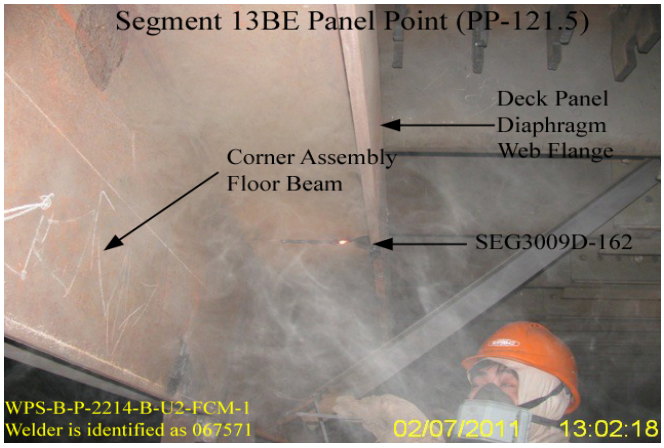

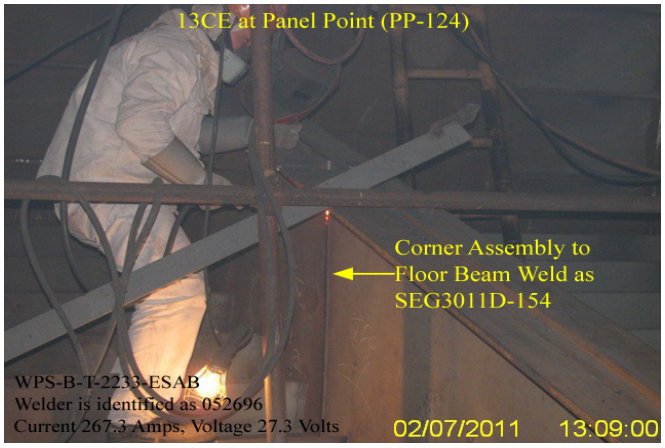

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer